Tuesday, 13/05/2008 11:08:50 AM

User

Julie Lecocq

# **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 39241 : 10010

**Estimate Number** 

P.O. Number

This Issue

: 13/05/2008 : NC

Prsht Rev. First Issue

: 1.1 : 38033

: SMALL /MED FAB

Type

S.O. No. :

Part Number

**Drawing Name** 

: D27353

**Drawing Number** 

: D2735 REV C

: LUG BRACKET

**Project Number Drawing Revision** 

: N/A

Material

**Due Date** 

: 30/05/2008

Qty:

40 Um:

Each

Written By

Comment

**Previous Run** 

Checked & pproved By

: Est Rev:C

05-10-25 Removed from 9 Digit

Est. C 06.07.21

waterjet EC JLM

**Additional Product** 

Job Number:



0.1733 sf(s)/Unit

Seq. #:

**Machine Or Operation:** 

Description:

1010-1025 sheet .125

1.0

M1010S125

Comment: Qtv.:

6.9300 sf(s)

1010-1025 sheet .125

batch: 107513

Total:

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2735 Dwg Rev: \_\_\_\_

Prog Rev:

16-2-8 BA

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

PARTS AS THEY COME OFF MACHINE Comment: INSPECT

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

2-Deburr if required.

Form: rprocess

contes

Page 1

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						: :			
Dowt No.		DAD # 5 140.4					<u> </u>		

Part No:	PAR #: Fault Category:	NCR: Yes No DQA: Date:
		QA: N/C Closed: Date:
NCR:	WORK ORDER NON-CONFO	ORMANCE (NCR)

NCR:			WORK ORDE	ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B		3	Verification					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
								Į.			

NOTE: Date & initial all entries

Tuesday, 13/05/2008 11:08:50 AM Date: User: Julie Lecocq **Process Sheet** Drawing Name: LUG BRACKET Customer: CU-DAR001 Dart Helicopters Services Part Number: D27353 Job Number: 39241 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHA	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	_ NCI	₹: Yes	No DQA	\:	Date:	<u> </u>
						QA:	N/C Closed	l:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NC	R) /			,
DATE	STEP	Description of NC	Initial		tion B	Sign	Verific	ation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date		on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39241
		· · · · · · · · · · · · · · · · · · ·
Description: Lug Bracket	Part Number:	D2735-3
Inspection Dwg: D2735 Rev: C		Page 1 of 1

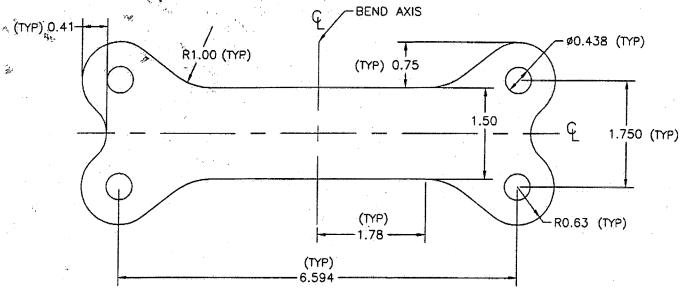
	x	First Artic	cle	_ Prote	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.41	+/-0.030	,416	L			
6.594	+/-0.010	6,591	×			,
R0.63	+/-0.030	.63	*			
1.750	+/-0.010	1,744	X			
Ø0.438	+0.006/-0.001	,439	×			
1.50	+/-0.030	9 = -	×	-		•
R1.00	+/-0.030	1,00	*			
1.50	+/-0.030	1.495	<b>×</b>			
0.125	+/-0.010	ماان	x			
·						
easured by:	<u> </u>	Audited by:	5,		Prototype Appro	
Date:	8-5-21	Date:	0805	21		Date: N/A



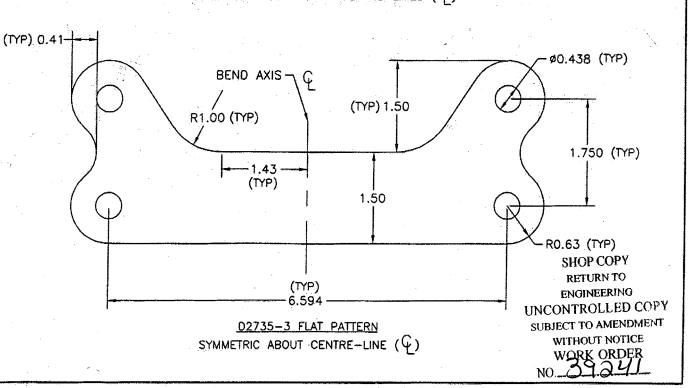


4		A RESTAURANT OF THE PROPERTY O		
DESIG	4-	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
CHEC	KED /	APPROVED	DRAWING NO.	REV. C
P	P	KE	D2735 shi	EET 1 OF 2
DATE			TITLE	SCALF.
98.	12.14		LUG BRACKET	2:3
Α		97.12.14	NEW ISSUE	

98.12.14	<u> </u>	LUG BRACKET	2:
Α	97.12.14	NEW ISSUE	
В	98.10.23	UPDATE MATERIAL (TSR A1114)	
С	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	)

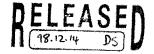


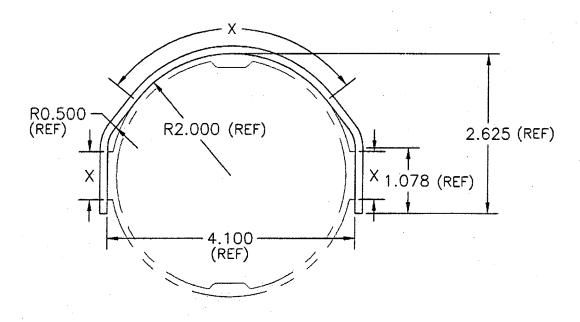
### D2735-1 FLAT PATTERN SYMMETRIC ABOUT BOTH CENTRE-LINES (4)





DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKED	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE	1	TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

### GENERAL NOTES

ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL MATERIAL:

0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

SHOP COPY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO ENGINEERING

ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK QRDER

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